

Work Order ID 61130

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Monday, August 09, 2010 9:57:09 AM

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 8/10/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/13/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MFDate: 10-8-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3838	Rev A								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open
to finish size as per dwg D3838A/R ER316 S.S. Rod Batch: 4114649

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: 4114649

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

SAP 10-08-12

(2) 10.08.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D3838-042	Accept		Setup	Start		
Revision ID:						Stop	
Item Name:	Rib Assembly (Basket Lid, RH)						
Start Date:	8/10/2010	Start Qty:	2.00		Cust Item ID:		
Required Date:	8/13/2010	Req'd Qty:	2.00		Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							 ② 10.08.19 2012
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							 ② 10.08.19
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>Basket</u> Memo	0.00 0.00							 ② 10.08.19

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Picklist Print

Monday, August 09, 2010 9:57:08 AM

Page 1

Work Order ID: 61130



Parent Item: D3838-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 8/10/2010

Required Date: 8/13/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 		Manufactured	No			100	Each	119.0000	1	2		10-08-19	

Bushing

Location	Loc Qty	Loc Code
ST084	60	
56942	60	
WA	59	
54072	9	
60241	8	
60719	42	

M304TS0.750W.065



304 SQ Tube .75x.75x.065W

Purchased

No

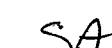
100

f

489.2170

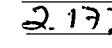
1.0317

2.172



SAD 10-08-12

Location	Loc Qty	Loc Code
MAT	1.4628	
112398	0	
114482	1.4628	
WA	487.754185	
114520	22.417985	
115274	465.3362	



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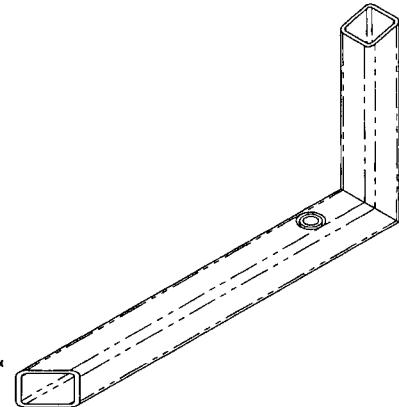
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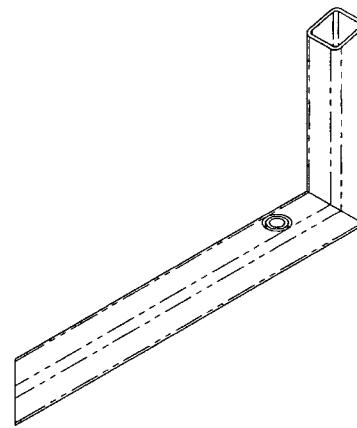
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

6/1/08
X

RELEASED
08/11/08 MWT

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	MSS		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	08.10.08	NTS	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3838 REV. A
SHEET 1 OF 3

TITLE RIB ASSY (BASKET LID)

SCALE NTS

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NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.54 lbs

8 7 6 5 4 3 2 1

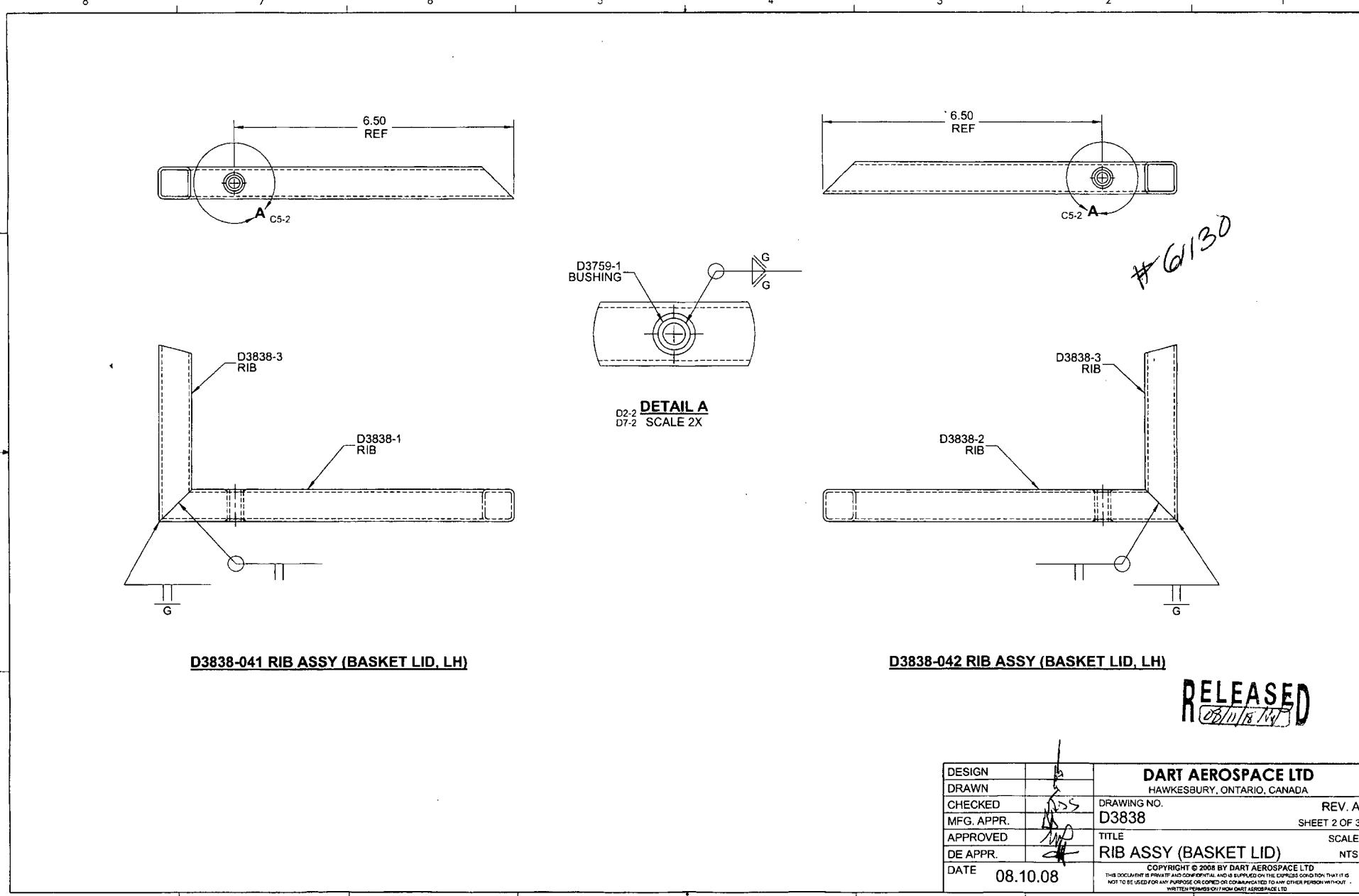
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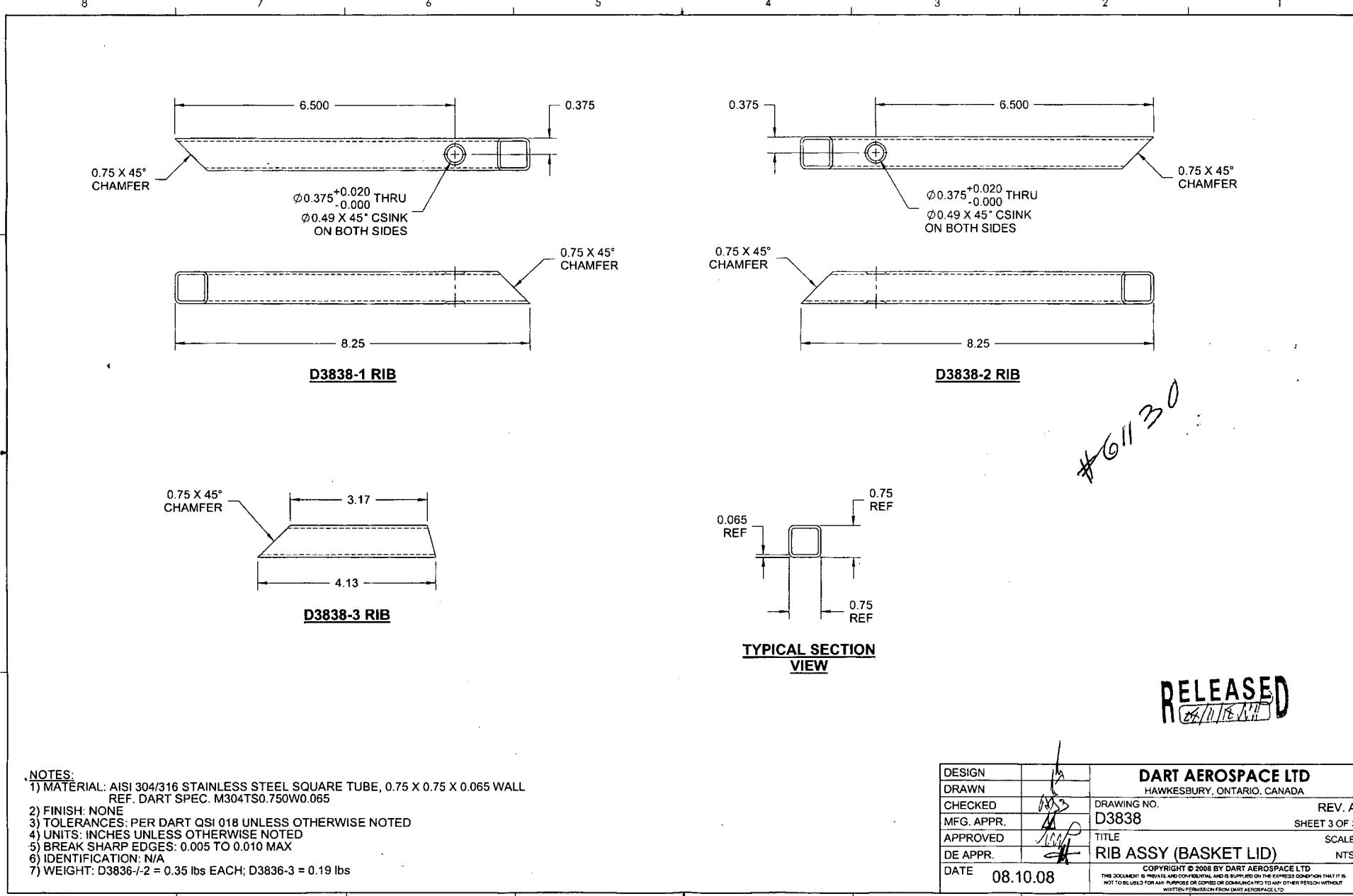
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